

Work Order ID 80729 - 2

\*80729\*

Page 1

February-28-12 10:32:45 AM

Item ID: D4154-041  
Revision ID:  
Item Name: Wearplate Assembly

Accept

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 28/02/2012 Start Qty: 6.00  
Required Date: 13/03/2012 Req'd Qty: 6.00

\*6\*  
\*6\* 4

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: MLJ  
QC:

Date: 12/02/28 Tooling:  
Date: SPC (Y/N):

Date:  
Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	B

100 0.00

\*100\*

Large Fab  
Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH#: m121175 → 2059B

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: m120013

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC  
Quality Control

Memo

0.00

12/05/03 12/MAL/ME

pto

12.05.07 6

Dart Aerospace Ltd

W/O: 80729-2		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/25/03 100	100	parts were already started - remove plates (destroy) make bars per New Rev.C - replace plates D4154-1 B. 83212 Qty. 6	EL #	12-5-03	6	CA PWS	

Part No: D4154-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**\*80729\***

Page 2

**\*N900040100\***

```
Setup Start *NS1*
Stop *NS2*
```

\*6\*

**Cust Item ID:**  
**Customer:**

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_  
 QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

120 QC5- Inspect part completeness to step on W/O

**\*120\***

QC

## Quality Control

## Memo

0.00

0.00

**\*150\***

### Small Fab

## Small Fab

## Memo

0.00

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154.

B121352

160 QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Quality Control

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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```
Setup  Start  *NS1*
      Stop   *NS2*
```

**Cust Item ID:**  
**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Identify as per dwg & Stock Location:

0.00

## Memo

0.00

### Packaging

## Packaging

QC21- Final Inspection - Work Order Release

0.00

## Memo

0.00

QC

## Quality Control

12058

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-28-12 10:32:49 AM

Page 1

Work Order ID: 80729

\*80729\*

Parent Item: D4154-041

\*D4154-041\*

Parent Item Name: Wearplate Assembly

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC  
10.11.04 added DT9684 DD verf:EC  
per dwg revB DD verf:EC

IPP Rev:B  
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1		Manufactured	No			100	Each	5.0000	1	6			

\*D4154-1\*

Plate

\*\*

83217 x 12

Location

WA

66312

77014

Loc Qty

5

1

4

Loc Code

12/05/03  
MAL/me/

D4155-1 Manufactured No

100 Each 2.0000 1 6

\*D4155-1\*

Bar

\*\*

82948 x 6

Location

WA

77013

Loc Qty

2

2

Loc Code

12/05/03  
MAL/me/  
X12  
X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

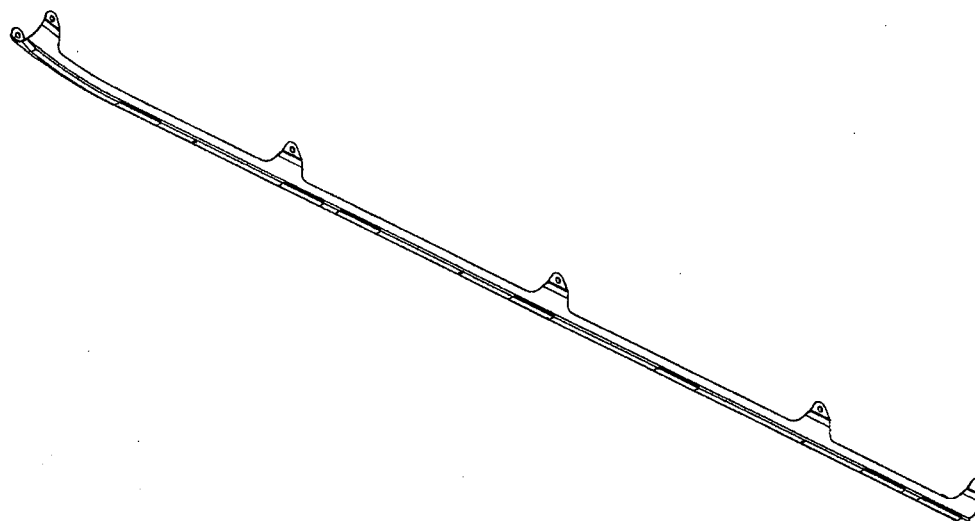
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**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



**D4154-041 WEARPLATE ASSEMBLY**

80729 MLS  
12/02/28

**RELEASED**  
2011-04-10  
MD

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED	SC	DRAWING NO.	REV. B	
MFG. APPR.	SC	D4154	SHEET 1 OF 3	
APPROVED	SC	TITLE	SCALE	
DE APPR.	SC	<b>WEARPLATE ASSEMBLY</b>	NTS	
DATE	11.04.05		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

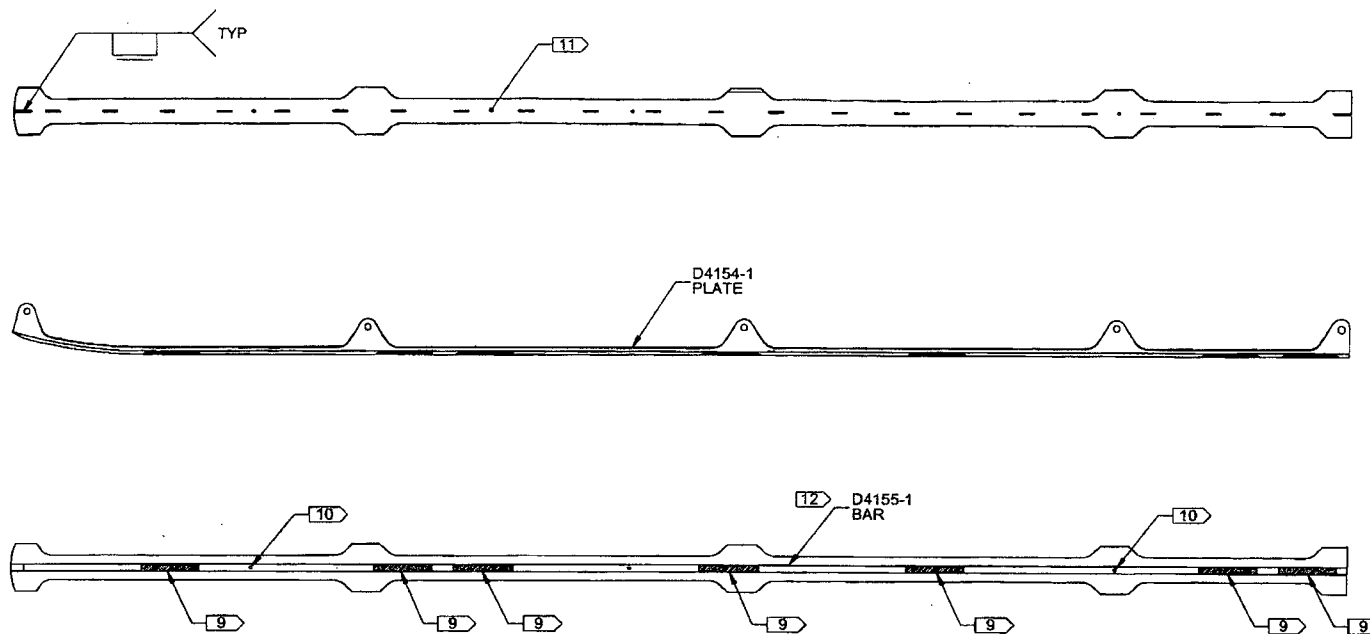
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

80729



# **D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2011-04-13

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	70	DRAWING NO.	REV. B
MFG. APPR.	10	D4154	SHEET 2 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE ASSEMBLY	NTS
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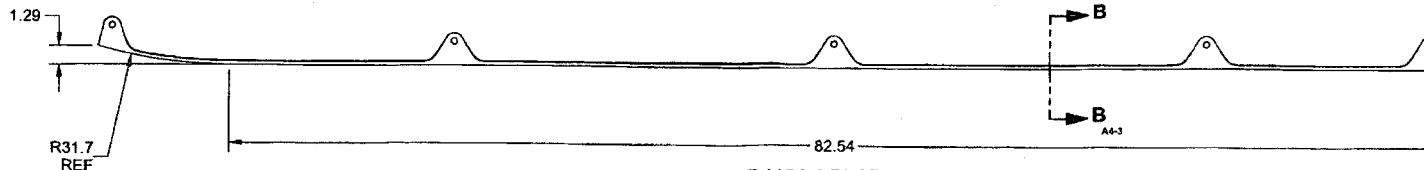
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

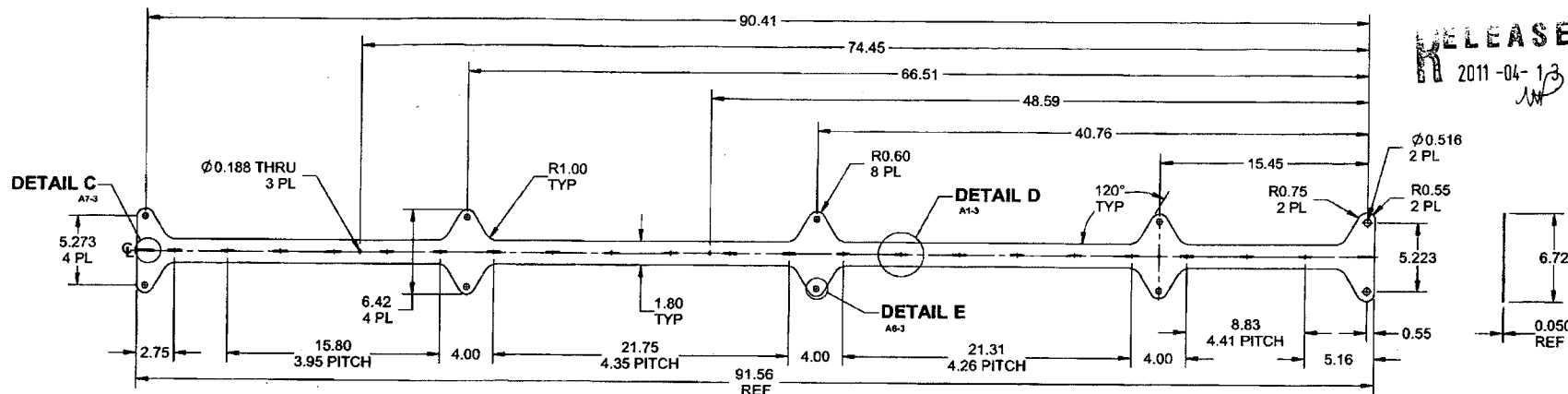
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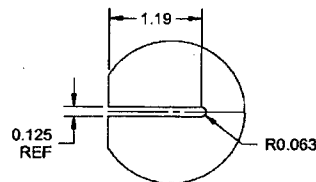
**NOTE:** Date & initial all entries



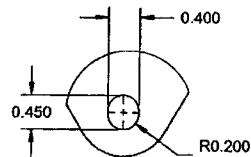
**D4154-1 PLATE**  
(MAKE FROM D4154-1F)



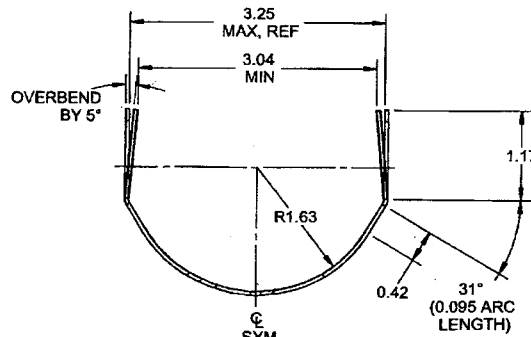
**D4154-1F FLAT PATTERN**



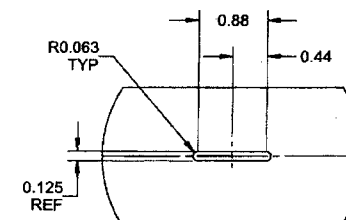
**DETAIL C**  
END SLOT DETAIL, 2 PL C7-3



**DETAIL E**  
SLOT DETAIL TYP C6-3



**SECTION B-B**  
D3-3



**DETAIL D**  
SLOT DETAIL TYP C4-3

**NOTES:**

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4154</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSEMBLY</b>	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries